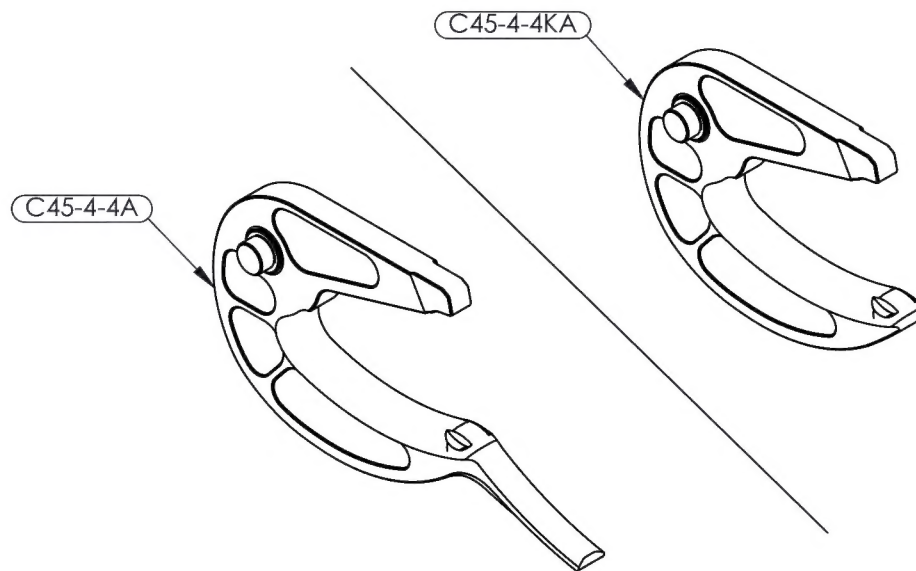


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
15		AS RELEASED BY CANAM.	9/18/2012		
16		CH'D DESIGN, REMOVED PIN AND ADDED FLAT TO TRUNNION AND LOAD BEAM.	10/30/2012	JAG	
17		ADDED NICKEL PLATE BAKE NOTE.	12/5/2013	JAG	
18	14-0126	CH'D TITLEBLOCK WAS RED BARN IS DART. <b>C45-4-2</b> ADDED BAG & LABEL NOTE. <b>C45-4-4</b> ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD	RW
19	15-0099	UPDATED TO NEW DRAFTING STANDARDS. <b>C45-4-2</b> CH'D HEAT TREAT WAS RC 34-37 IS RC 42-46. <b>C45-4-4</b> & <b>C45-4-4K</b> CH'D MAT'L WAS 4340 IS 4140/4142. <b>C45-4-4</b> DELETED DIMS 2.95, 2.05, 1.43, 1.13, .97, .94, .56, .57, 1.47, .333, R.31, R.50, R.50, R.38, R.38. <b>C45-4-4KA</b> AND <b>C45-4-4K</b> ADDED TO DRAWING FOR KEEPERLESS OPTION. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/8/2015	RJC	JAG
20	17-0133	<b>C45-4-2</b> DELETED DIM 2X R.03.	6/5/2017	RJC	JAG

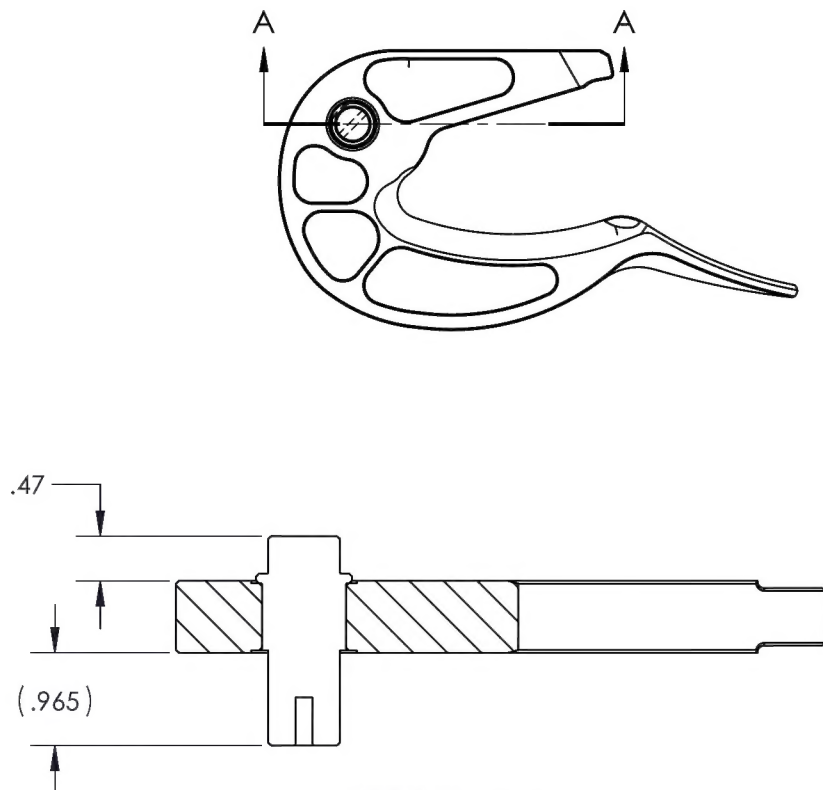


<b>DART AEROSPACE</b>																											
TITLE <b>C45 LOAD BEAM ASSEMBLIES</b>																											
DWG NO. <b>C45-4-4A /C45-4-4KA</b>	REV <b>20</b>																										
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125°</td> </tr> <tr> <td>DRAWN BY:</td> <td>CLOUGH</td> </tr> <tr> <td>CHECKED:</td> <td>DD 06/05/2017</td> </tr> <tr> <td>OPPS APPR:</td> <td>AA 06/06/2017</td> </tr> <tr> <td>QA APPR:</td> <td>JL 06/14/2017</td> </tr> <tr> <td>APPROVED:</td> <td>JAG 06/15/2017</td> </tr> <tr> <td>SCALE</td> <td>1:4</td> </tr> <tr> <td>DATE</td> <td>5/7/2015</td> </tr> <tr> <td colspan="2">SHEET 1 OF 6</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125°	DRAWN BY:	CLOUGH	CHECKED:	DD 06/05/2017	OPPS APPR:	AA 06/06/2017	QA APPR:	JL 06/14/2017	APPROVED:	JAG 06/15/2017	SCALE	1:4	DATE	5/7/2015	SHEET 1 OF 6	
MAT'L	UNLESS OTHERWISE SPECIFIED																										
HEAT TREAT	DIMENSIONS ARE IN INCHES																										
FINISH	.XXX ± .005 FRACTIONS ± 1/8																										
SPEC	.XX ± .01 ANGLES ± 5°																										
	.X ± .1 SURFACES = 125°																										
DRAWN BY:	CLOUGH																										
CHECKED:	DD 06/05/2017																										
OPPS APPR:	AA 06/06/2017																										
QA APPR:	JL 06/14/2017																										
APPROVED:	JAG 06/15/2017																										
SCALE	1:4																										
DATE	5/7/2015																										
SHEET 1 OF 6																											

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		C45-4-4A	1	C45 LOAD BEAM ASSY.			2
1	1		C45-4-2		TRUNNION	4140/4142		3
	1		C45-4-4		LOAD BEAM	4140/4142		4
X			C45-4-4KA	1	C45 LOAD BEAM KEEPERLESS ASSY.			5
1			C45-4-4K		C45 LOAD BEAM KEEPERLESS	4140/4142		6
ASSY C45-4-4KA	ASSY C45-4-4A							

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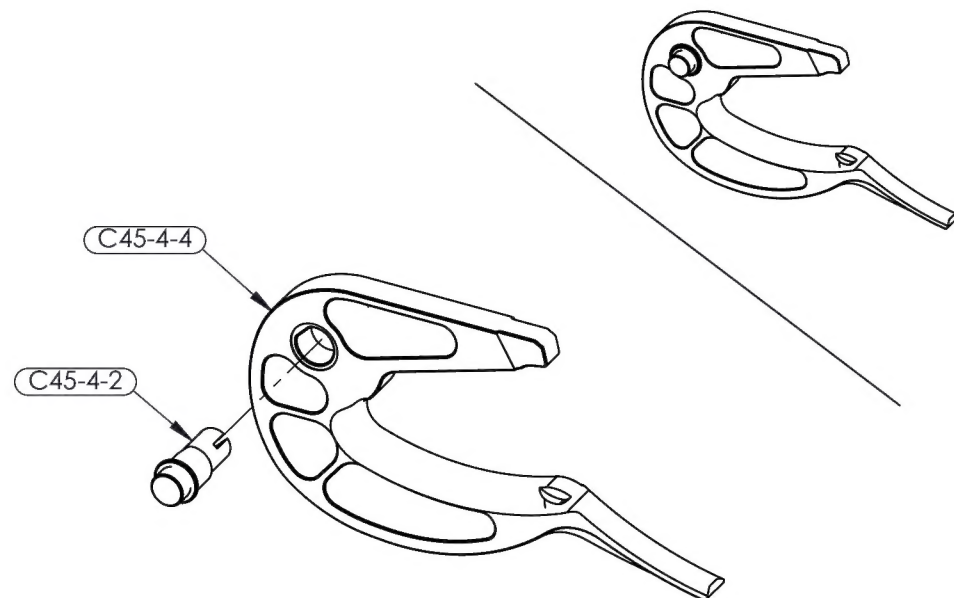
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
15		AS RELEASED BY CANAM.	9/18/2012		
16		CH'D DESIGN, REMOVED PIN AND ADDED FLAT TO TRUNNION AND LOAD BEAM	10/30/2012	JAG	
17		ADDED NICKEL PLATE BAKE NOTE	12/5/2013	JAG	



SECTION A-A  
SCALE 1 : 2

C45-4-4A

C45 LOAD BEAM ASSY.

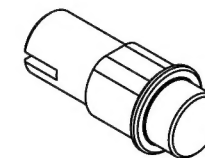
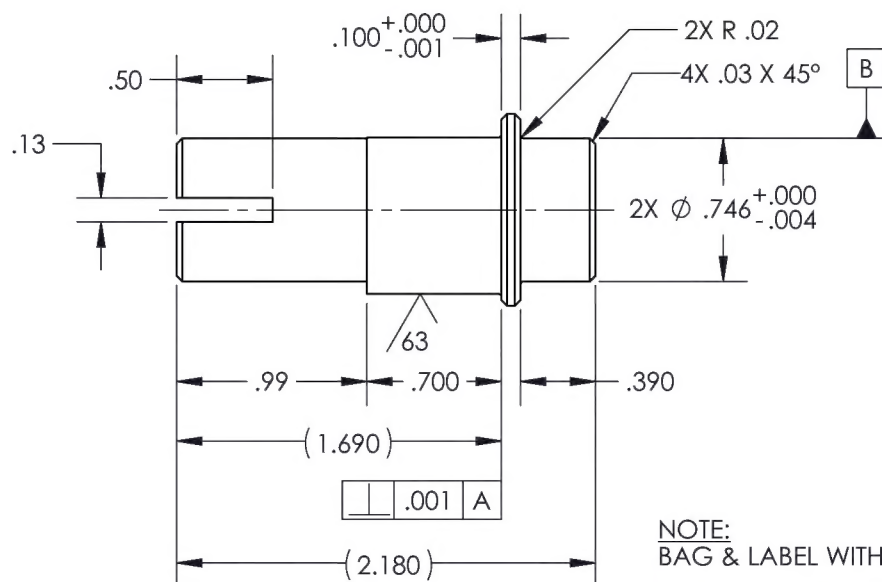
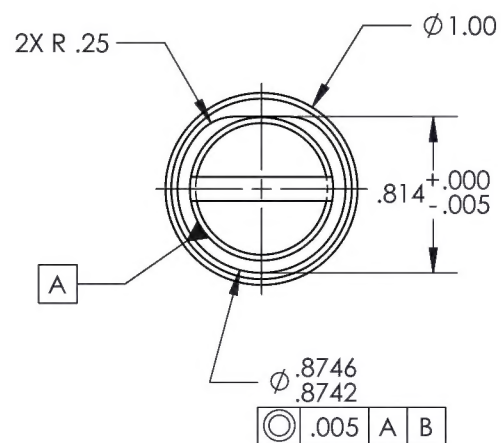


NOTE:  
1. NICKEL PLATE .0009 - .0011, BAKE AFTER PLATING.

<b>DART AEROSPACE</b>	
TITLE <b>C45 LOAD BEAM ASSEMBLIES</b>	
DWG NO. <b>C45-4-4A / C45-4-4KA</b>	REV <b>20</b>
MAT'L HEAT TREAT FINISH SEE NOTE 1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CANAM	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 06/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 06/06/2017	USED ON MODEL
QA APPR: JL 06/14/2017	
APPROVED: JAG 06/15/2017	
SCALE 1:4	DATE 11/17/2009
SHEET 2 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM.	2/14/2005		
16		INCREASED CENTER DIAMETER AND ADDED FLAT.	9/12/2012	JAG	
18	14-0126	C45-4-2 ADDED BAG & LABEL NOTE.	8/13/2014	DPD	RW
19	15-0099	C45-4-2 CH'D HEAT TREAT WAS RC 34-37 IS RC 42-46.	5/8/2015	DPD	JAG
20	17-0133	C45-4-2 DELETED DIM 2X R.03.	6/5/2017	RJC	JAG



NOTE:  
BAG & LABEL WITH BATCH NUMBER.

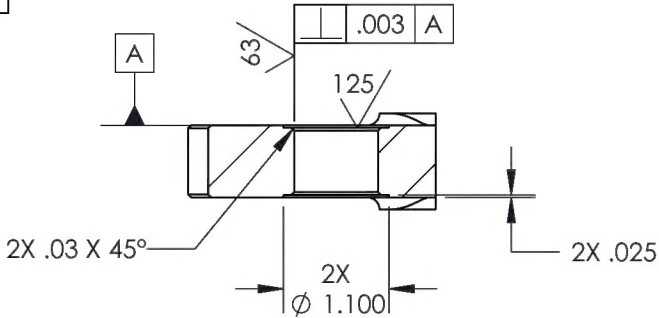
C45-4-2

TRUNNION

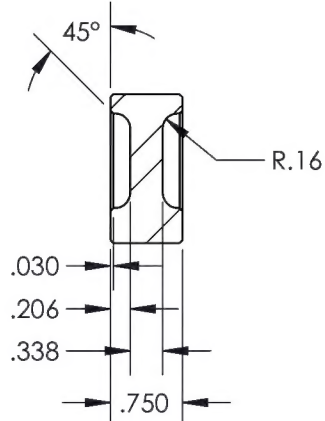
<b>DART</b> AEROSPACE	
TITLE <b>C45 LOAD BEAM ASSEMBLIES</b>	
DWG NO. <b>C45-4-4A / C45-4-4KA</b>	REV <b>20</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT HRC 42-46	DIMENSIONS ARE IN INCHES
FINISH SEE SHEET 1	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
SPEC	.XX $\pm .01$ ANGLES $\pm 5^\circ$
DRAWN BY: GILBERT	.X $\pm .1$ SURFACES = 125
CHECKED: DD 06/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 06/06/2017	.015 x 45° OR .015R
QA APPR: JL 06/14/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 06/15/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/12/2012	USED ON MODEL
SHEET 3 OF 6	

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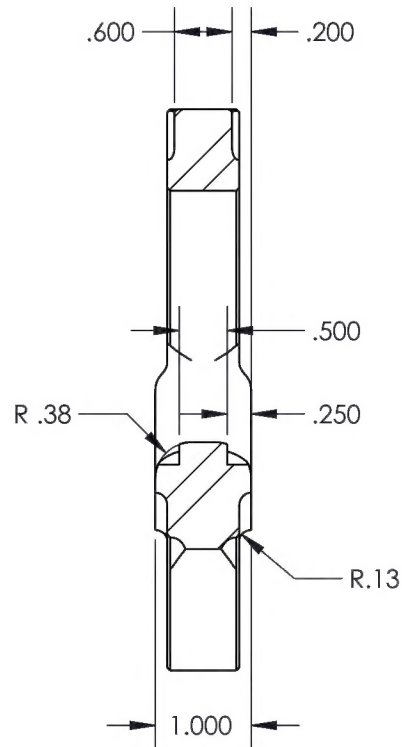
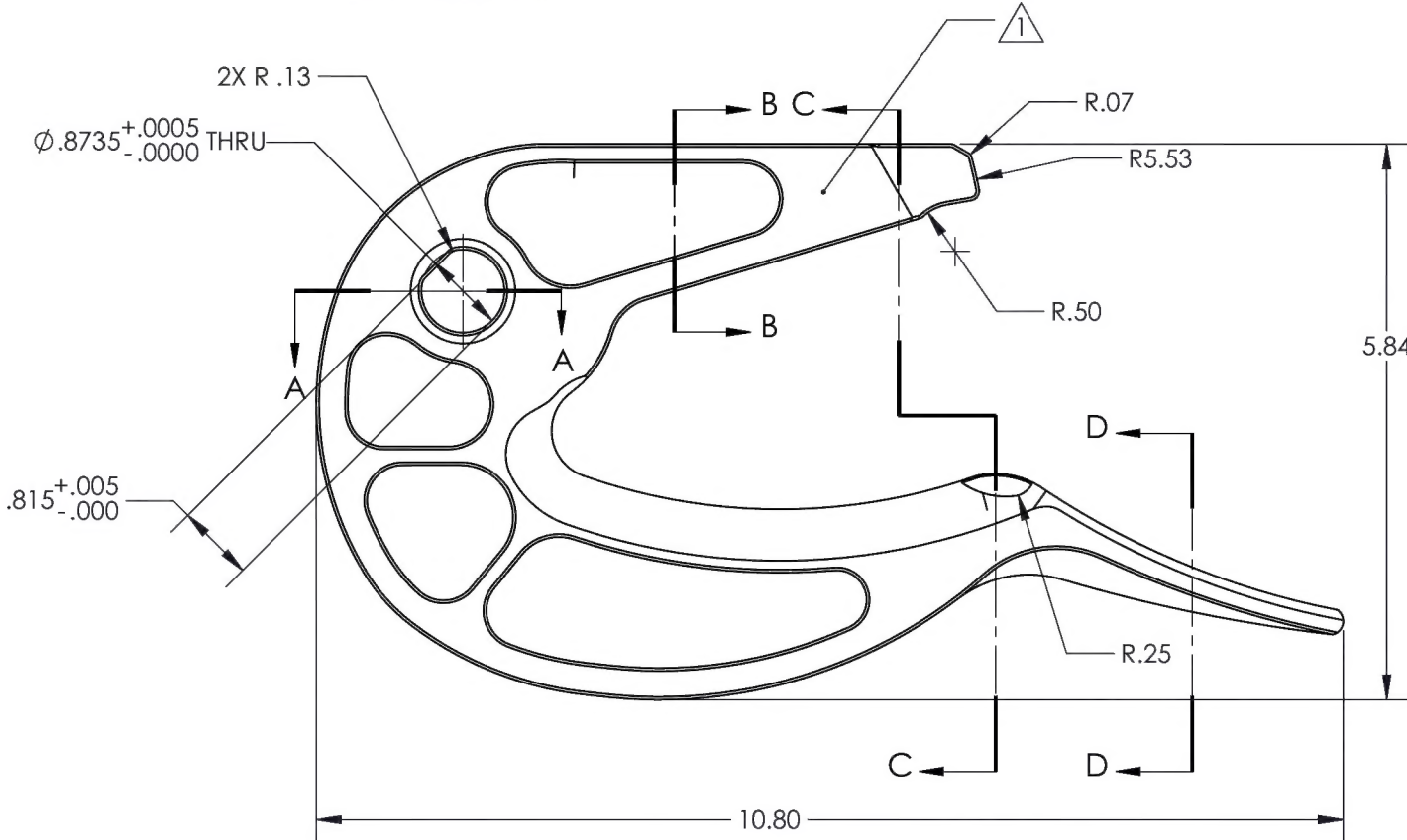
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
15		AS DRAWN BY CANAM.	11/17/2009		
16		INCREASED HOLE FROM Ø.750 TO Ø.8735, AND ADDED FLAT.	9/12/2012	JAG	
18	14-0126	<b>C45-4-4</b> ADDED MACHINE ENGRAVE NOTE.	8/13/2014	DPD	RW
19	15-0099	<b>C45-4-4</b> DELETED DIMS 2.95, 2.05, 1.43, 1.13, .97, .94, .56, .57, 1.47, .333, R.31, R.50, R.50, R.38, R.38.	7/27/2015	DPD	JAG



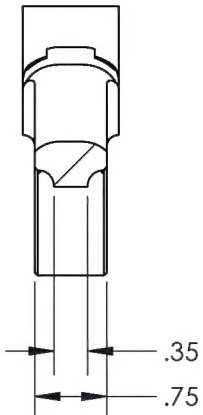
SECTION A-A



SECTION B-B  
TYP 4 PLCS



SECTION C-C



SECTION D-D

NOTES:

1. MACHINE ENGRAVE BATCH NUMBER.  
2. USE DXF PROFILE FOR PART CONTOURS.



TITLE C45 LOAD BEAM ASSEMBLIES

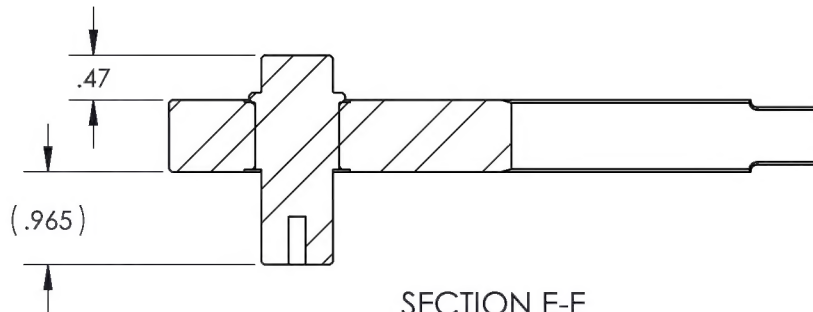
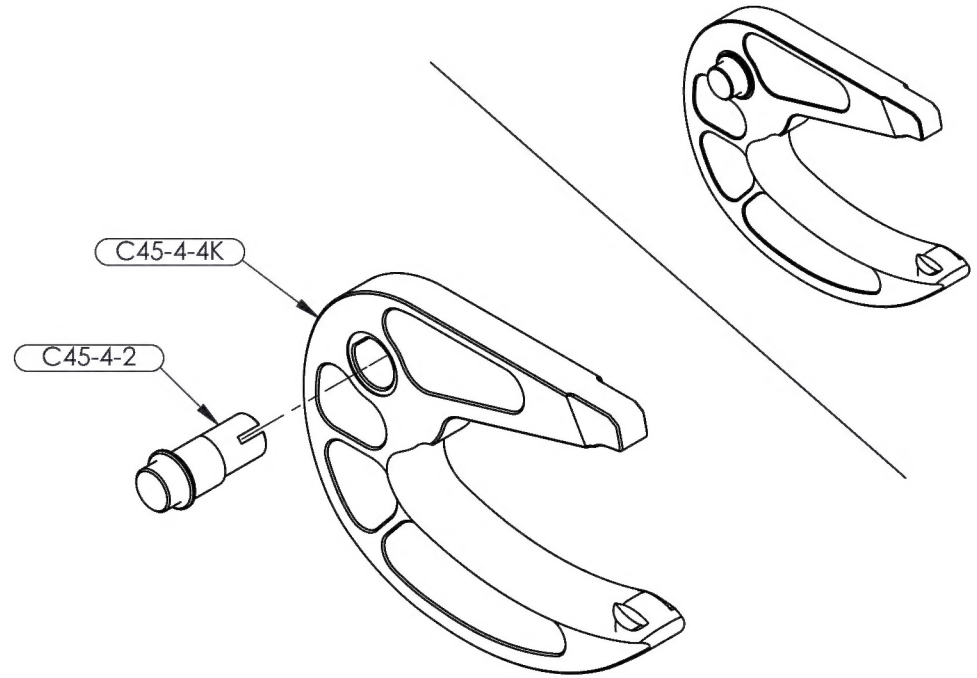
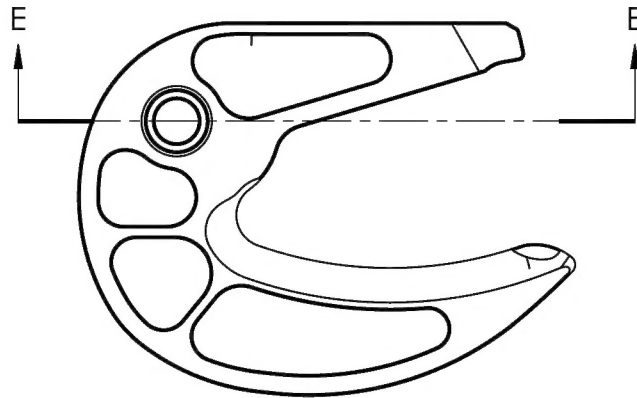
DWG NO. C45-4-4A / C45-4-4KA

MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT RC 53-56		DIMENSIONS ARE IN INCHES	
FINISH SEE SHEET 1		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125 ✓	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DD 06/05/2017		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: AA 06/06/2017		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: JL 06/14/2017		USED ON MODEL	
APPROVED: JAL 06/15/2017			
SCALE 1:2	DATE 9/12/2012	SHEET 4 OF 6	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
19	15-0099	C45-4-4KA ADDED TO DRAWING FOR KEEPERLESS OPTION.	5/8/2015	RJC	JAG



SECTION E-E  
SCALE 1 : 2

(C45-4-4KA)

C45 LOAD BEAM KEEPERLESS ASSY.

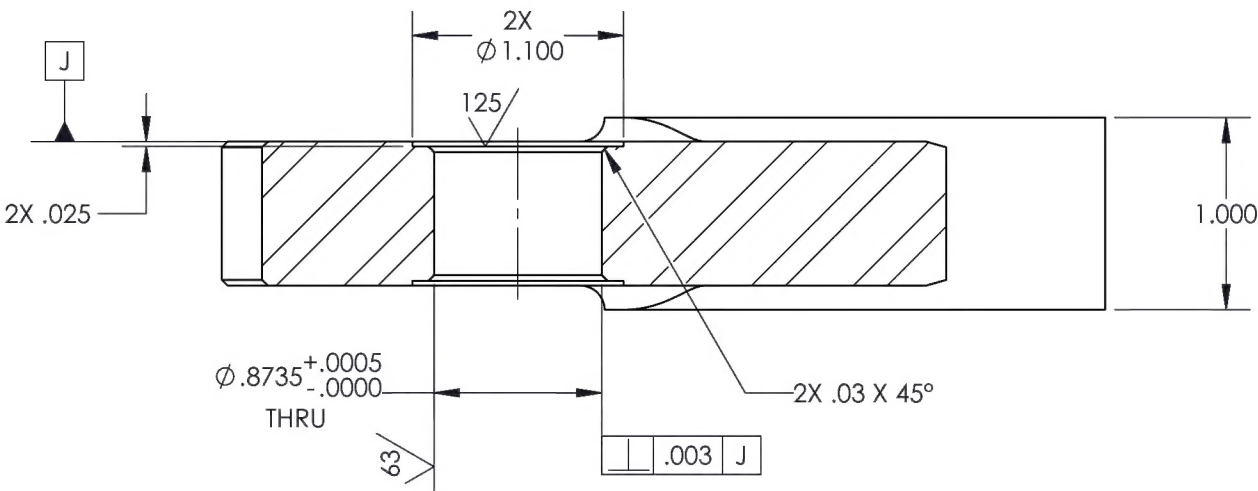
NOTE:

1. NICKEL PLATE .0009 - .0011, BAKE AFTER PLATING.

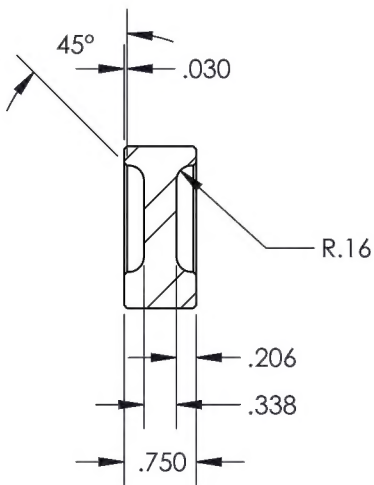
<b>DART AEROSPACE</b>	
TITLE <b>C45 LOAD BEAM ASSEMBLIES</b>	
DWG NO. <b>C45-4-4A / C45-4-4KA</b>	REV <b>20</b>
MAT'L _____ HEAT TREAT _____ FINISH SEE NOTE 1 SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DD 06/05/2017	
OPPS APPR: AA 06/06/2017	
QA APPR: JL 06/14/2017	
APPROVED: JAG 06/15/2017	
SCALE 1:3	DATE 5/7/2015 SHEET 5 OF 6

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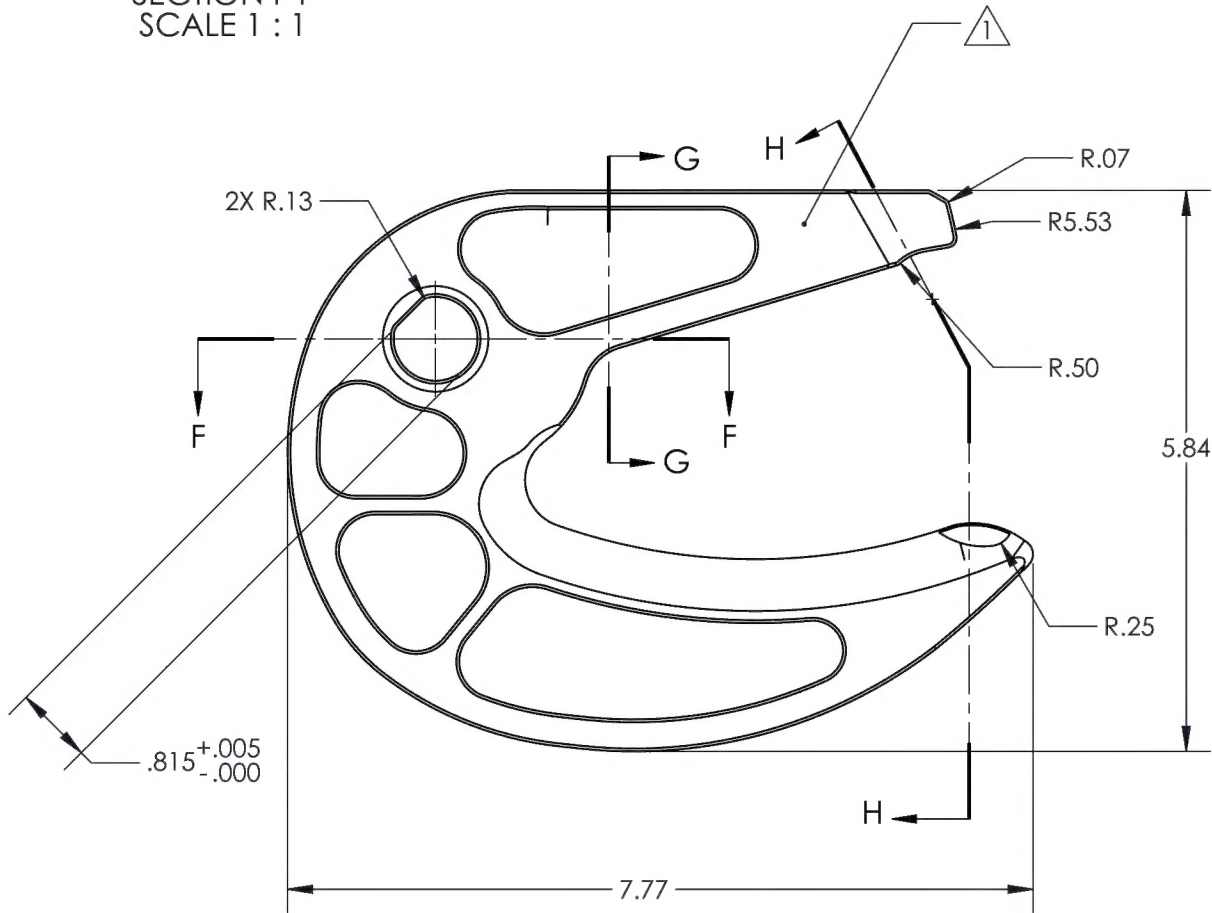
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
19	15-0099	C45-4-4K ADDED TO DRAWING FOR KEEPERLESS OPTION.	5/8/2015	RJC
				JAG



SECTION F-F  
SCALE 1 : 1

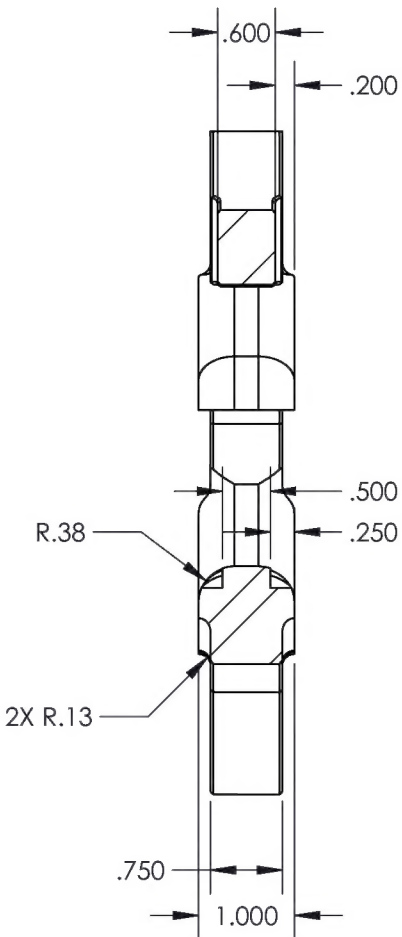
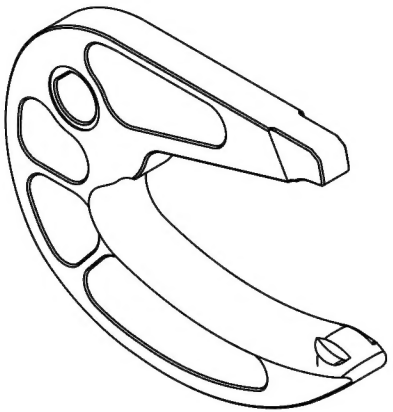


SECTION G-G  
TYP 4 PLACES



C45-4-4K

C45 LOAD BEAM KEEPERLESS



SECTION H-H

- NOTE:
1. MACHINE ENGRAVE BATCH NUMBER.
  2. USE DXF PROFILE FOR PART CONTOURS.

DART AEROSPACE			
TITLE C45 LOAD BEAM ASSEMBLIES			
DWG NO. C45-4-4A / C45-4-4KA			REV 20
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT RC 53-56		DIMENSIONS ARE IN INCHES	
FINISH SEE SHEET 1		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125	
CHECKED: DD 06/05/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 06/06/2017		.015 x 45° OR .015R	
QA APPR: JL 06/14/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 06/15/2017		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER	
DATE 9/12/2012		ASME Y14.5M-2009	
SHEET 6 OF 6		USED ON MODEL	